

Date: Friday, 2/17/2006 10:37:40 AM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEBBING TIDY
Job Number :	25880		
Estimate Number :	11381		
P.O. Number :	NIA	Part Number :	D32153
This Issue :	2/17/2006	S.O. No. :	NIA
Prsht Rev. :	NC	Drawing Number :	D3215 REV C
First Issue :	MIA	Project Number :	N/A
Previous Run :	25479	Drawing Revision :	C
		Material :	NIA
		Due Date :	2/24/2006
Written By :	SEE COMMENT BELOW		
Checked & Approved By :	SEE ABOVE DATE & USER		
Comment :	Est. A04.01.06 New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 0.0271 sf(s)/Unit Total: 1.0836 sf(s)
5052-H32 .040 Sheet
Material: 5052-H32 (QQ-A-250/8) 0.040" thick
(M5052H32S.040)
Identify for D3215-3A
Batch: M1801A

ml 06/02/18 40

2.0	SHEAR	SHEAR
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Comment: SHEAR
Cut blank: 2.562" x 0.880", grain along 2.562"

ml 06/02/18 40

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine D3215-3A as per Folio FA376 and dimensions
Use Stack of 10
Identify as D3215-3A

ml 06/02/18 40

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/02/18 40

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
Deburr SAD 06/02/18

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/17/2006 10:37:40 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 25880

Part Number: D32153

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/02/20

7.0

M5052H32S040

5052-H32 .040 Sheet



Comment: Qty.: 0.0271 sf(s)/Unit Total : 1.0836 sf(s)

5052-H32 .040 Sheet

Material: 5052-H32 (QQ-A-250/8) 0.040" thick

(M5052H32S.040)

Identify as D3215-3B

Batch: M18619

SAD 06-02-20

8.0

SHEAR

SHEAR



Comment: SHEAR

Cut blank: 2.130" x 0.530"

Deburr D3215-3A/-3B

SAD 06-02-20

9.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form D3215-3A as per Dwg D3215

SB 06/02/20

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-02-20

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D3215-3 by joining D3215-3A and D3215-3B as per Dwg D3215 and QSI 004

Identify as D3215-3

Grind flush

CPL 06-02-21

40

12.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06/02/21

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *SD* Date: 26/02/23

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: WEBBING TIDY

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Part Number: D32153

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FC 06 02 21

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FC 06 02 21

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 06 02 22

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

LOC: ST 416

ID: 102122

C 206102122

(40)

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/02/23

Job Completion



U 06-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

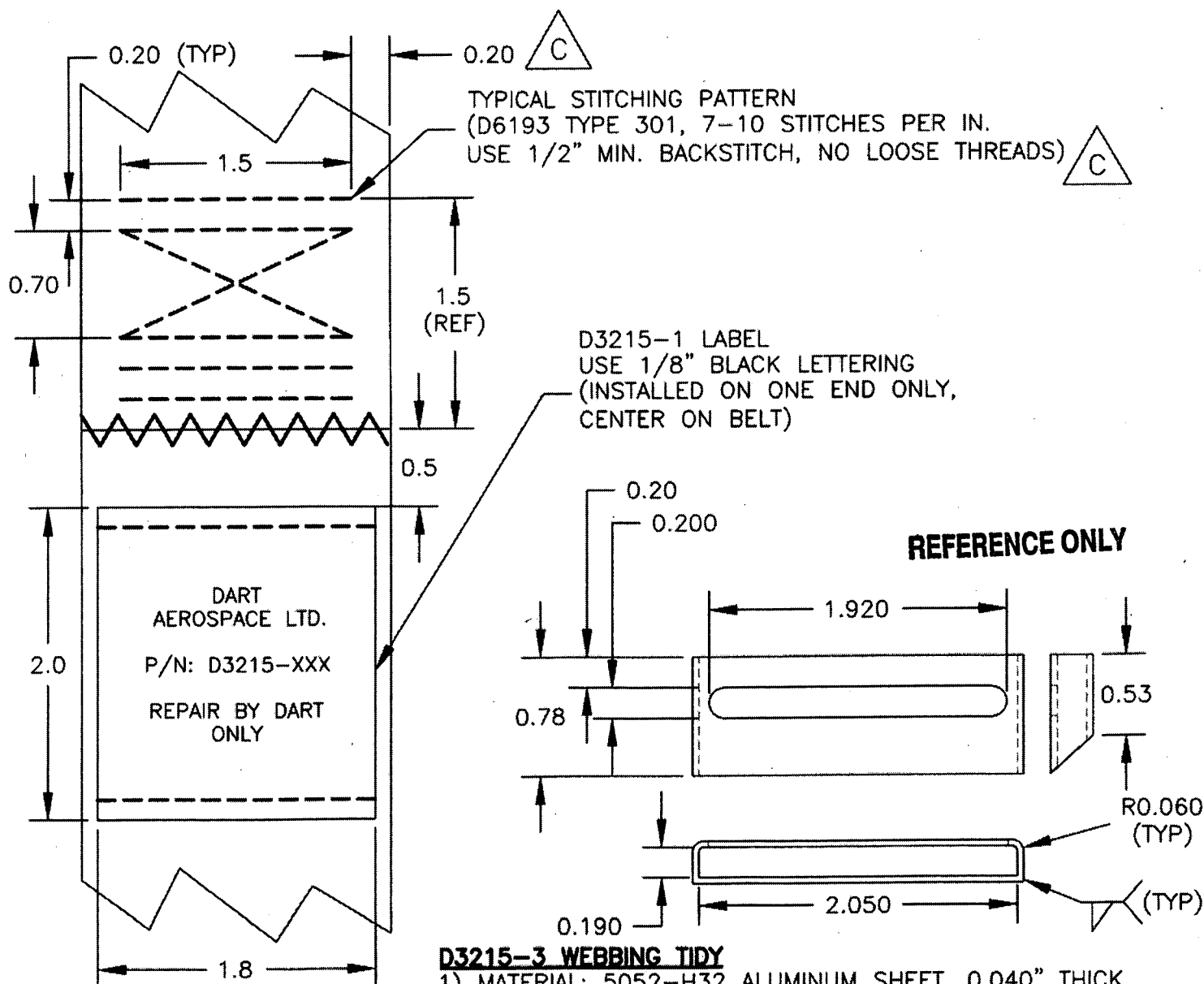


DESIGN GP	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3215	REV. C SHEET 3 OF 3
DATE 04.03.05		TITLE HARNES ASSEMBLY	SCALE 1:1

VIEW A-A

XXX = 041 FOR D3215-041

XXX = 043 FOR D3215-043



RELEASED
04.03.08

D3215-3 WEBBING TIDY

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.040" THICK
(REF DART SPEC. M5052H32S.040)
- 2) WELD PER DART QSI 004
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
NOTED

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